

Date: Tuesday, 10/02/2009 3:09:12 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
Job Number : 45715
Estimate Number : 12734
P.O. Number :
This Issue : 10/02/2009 S.O. No. :
Prsht Rev. : NC Part Number : D353525
First Issue : / / Type : SMALL /MED FAB Drawing Number : D3535 REV B
Previous Run : 45350 Project Number : N/A
Drawing Revision : B
Material :
Due Date : 24/02/2009 Qty: 10 Um: Each
Written By :
Checked & Approved By : Jul 09.02.10
Comment : Est Rev:A New Issue 07-02-15 JLM
Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.5355 sf(s)/Unit Total : 5.3550 sf(s)
304/316 .040 Sheet
(M304S20GA)
Batch: 110076 IB 9-3-3

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3535
Dwg Rev: B
Prog Rev: B

IB 9-3-3

(13)

2-Deburr if necessary IB 9-3-3

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-3-3

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SB 09/03/03

(13)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326
2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25

SB 09/03/05

(13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:09:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 45715

Part Number: D353525

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/02/05 (X13)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

12:00

OVEN TEMPERATURE:

320°

FINISH TIME:

12:30

BK 09-03-6 (B)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 09/03/06 (13X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-P 18

09/03/06 (13X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10 (13X)

Job Completion



mf 09-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: H5715
Description: Wearshoe		Part Number: D3535-25
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

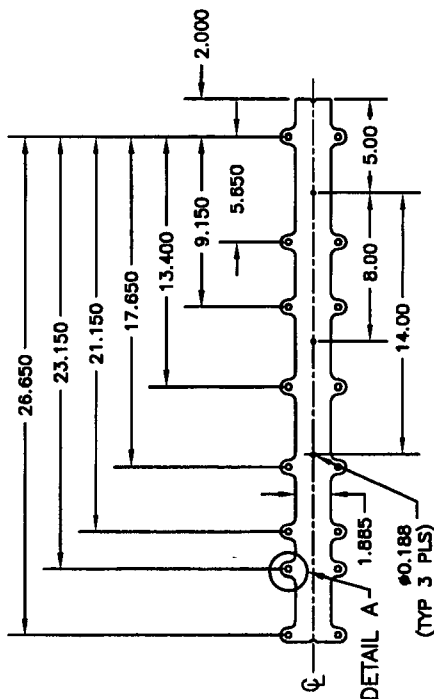
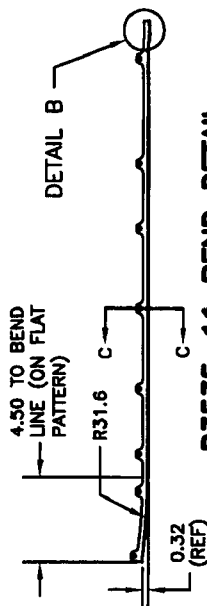
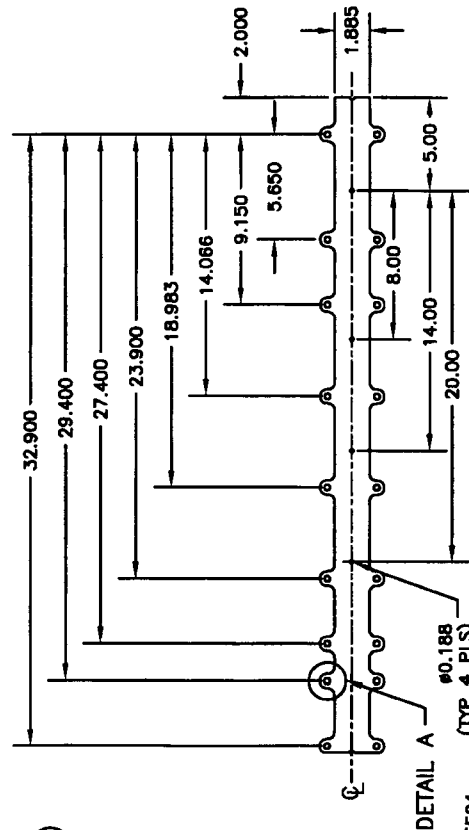
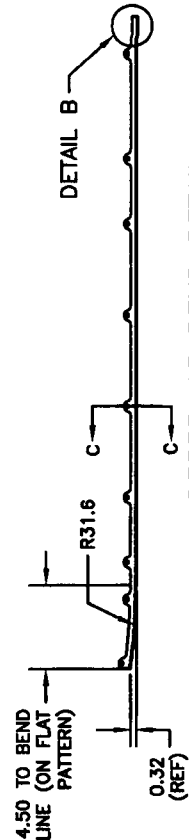
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.886	X			
1.937	+/-0.010	1.938	X			
1.450	+/-0.010	1.451	X			
5.450	+/-0.010	5.448	X			
10.900	+/-0.010	10.898	X			
16.350	+/-0.010	16.350	X			
21.800	+/-0.010	21.800	X			
Ø0.188	+0.005/-0.001	.196	X			
12.750	+/-0.010	12.750	X			
6.75	+/-0.030	6.75	X			
6.00	+/-0.030	6.00	X			
0.300	+/-0.010	.301	X			
0.300	+/-0.010	.302	X			
0.038	+/-0.010	.039	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-3-3	Date: 09/03/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

DART

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 1 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:10
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

RELEASED07.04.24 *[Signature]***D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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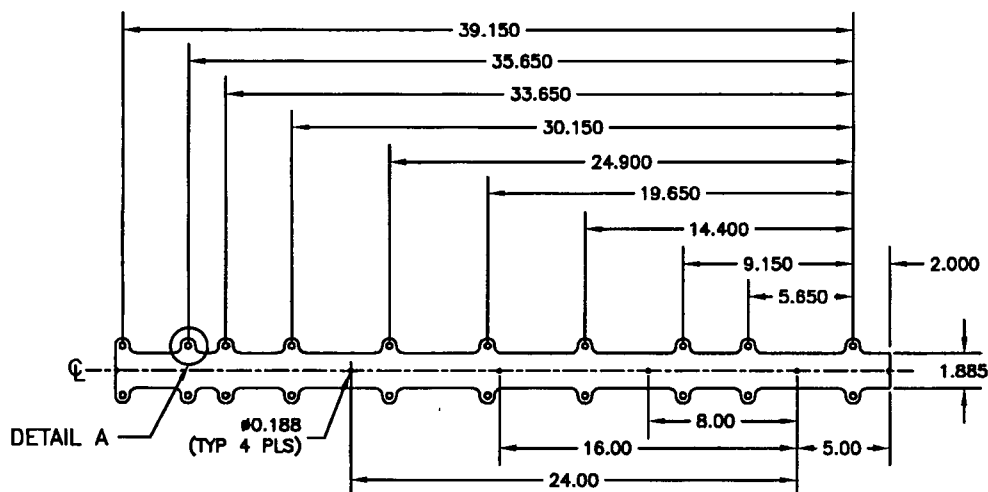
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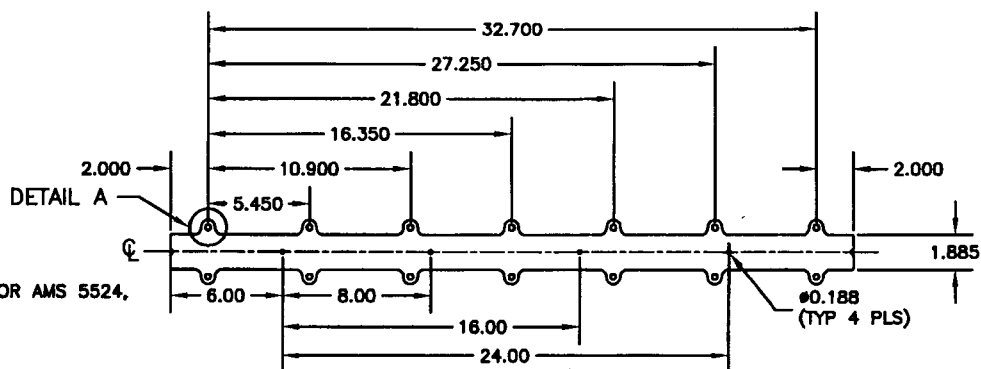
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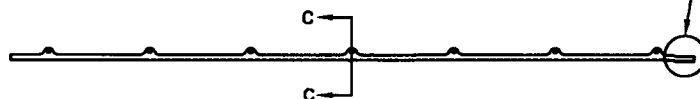
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DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	

**D3535-15F FLAT PATTERN**4.50 TO BEND
LINE (ON FLAT
PATTERN)0.32
(REF)

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D3535-15 BEND DETAIL**D3535-21F FLAT PATTERN**

DETAIL B

**D3535-21 BEND DETAIL****NOTES**

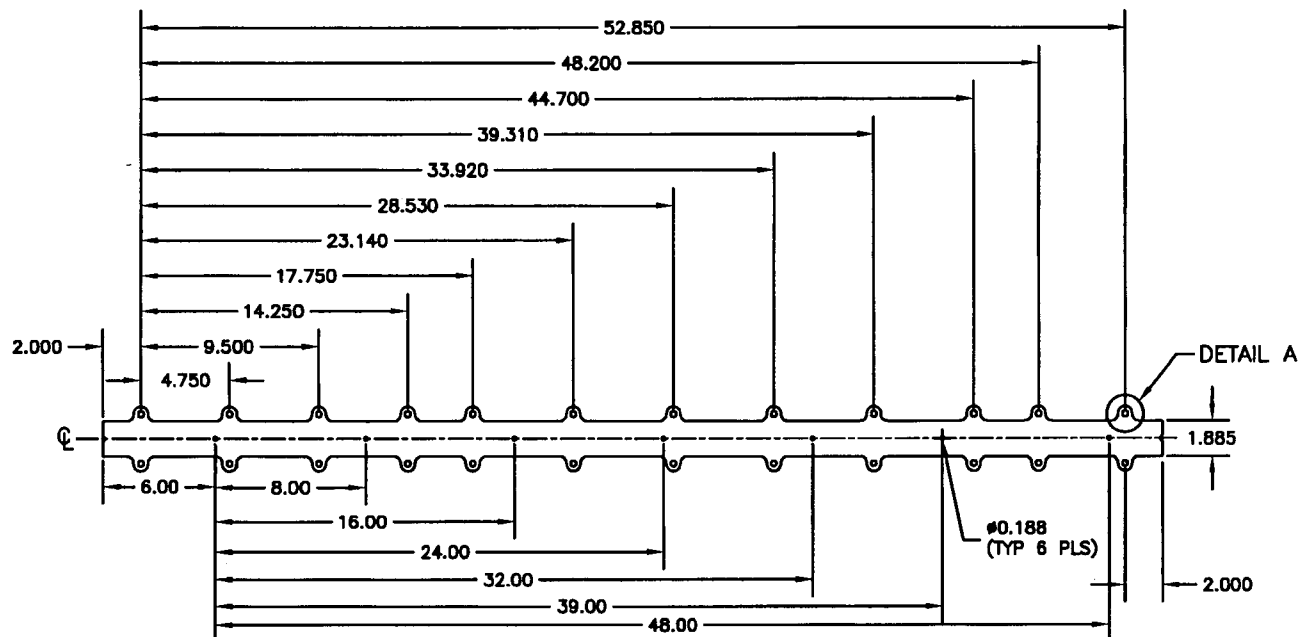
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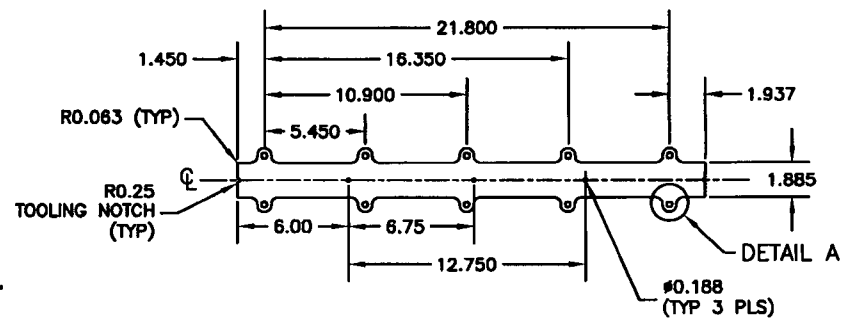
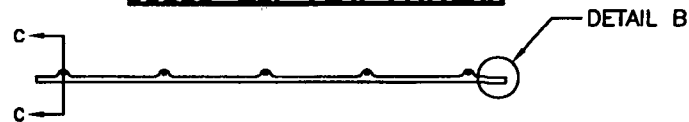
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#	#	D3535	SHEET 3 OF 7
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**D3535-23F FLAT PATTERN**

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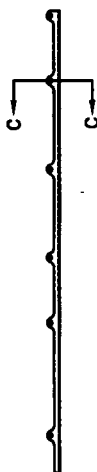
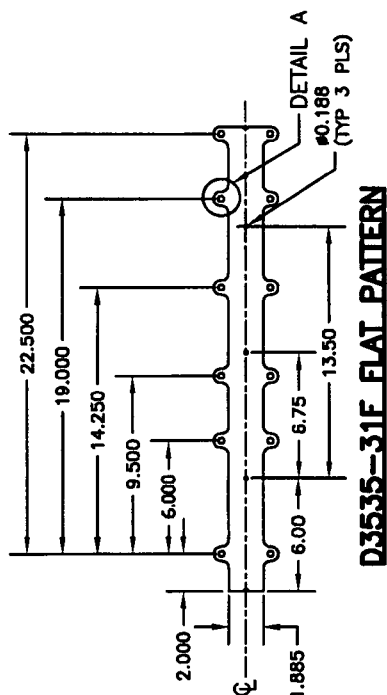
D3535-23 BEND DETAIL**D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

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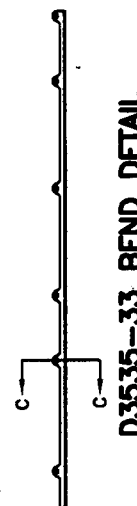
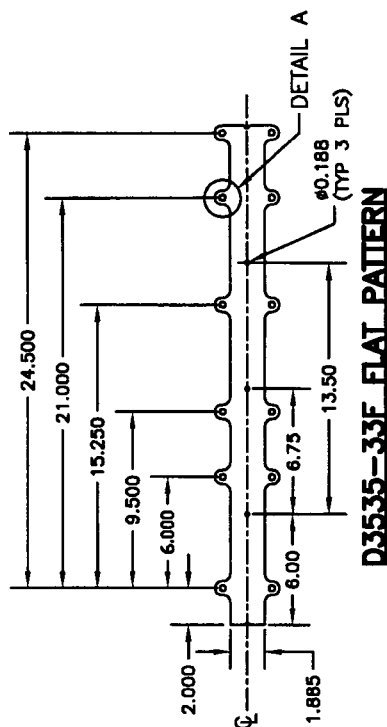
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07.04.24 *[Signature]***D3535-31 BEND DETAIL**

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**D3535-33 BEND DETAIL**

- NOTES**
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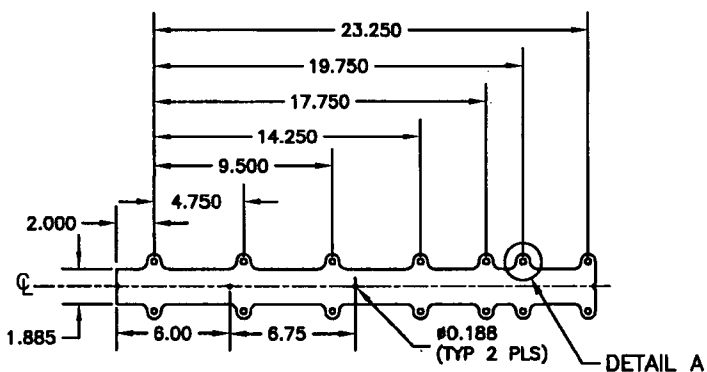
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D3535-35F FLAT PATTERN

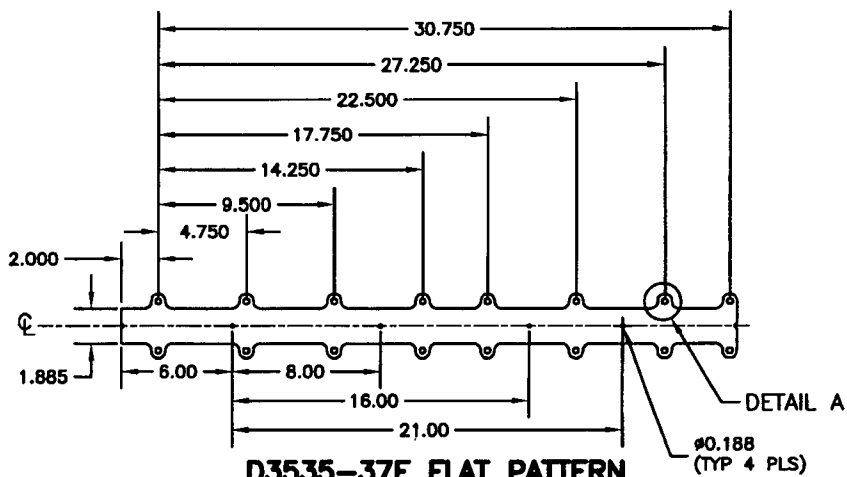


D3535-35 BEND DETAIL

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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D3535-37F FLAT PATTERN



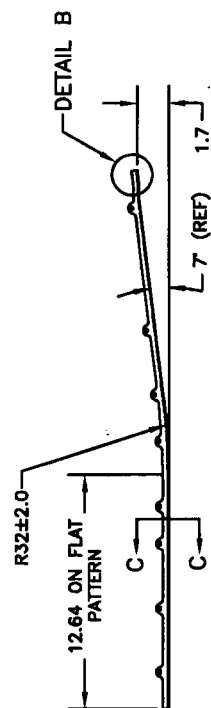
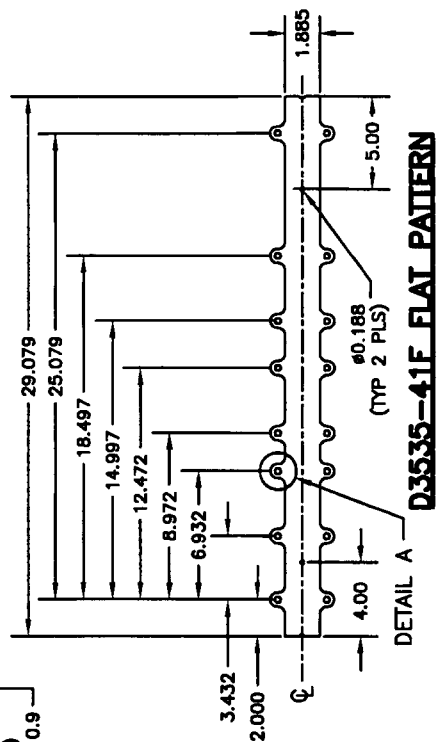
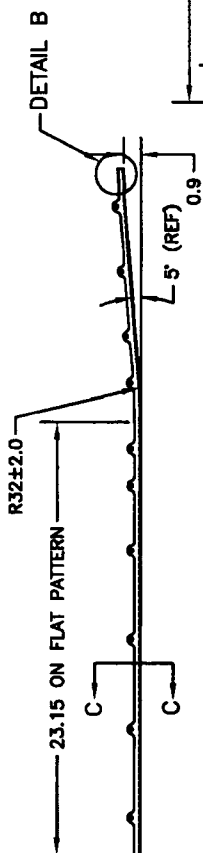
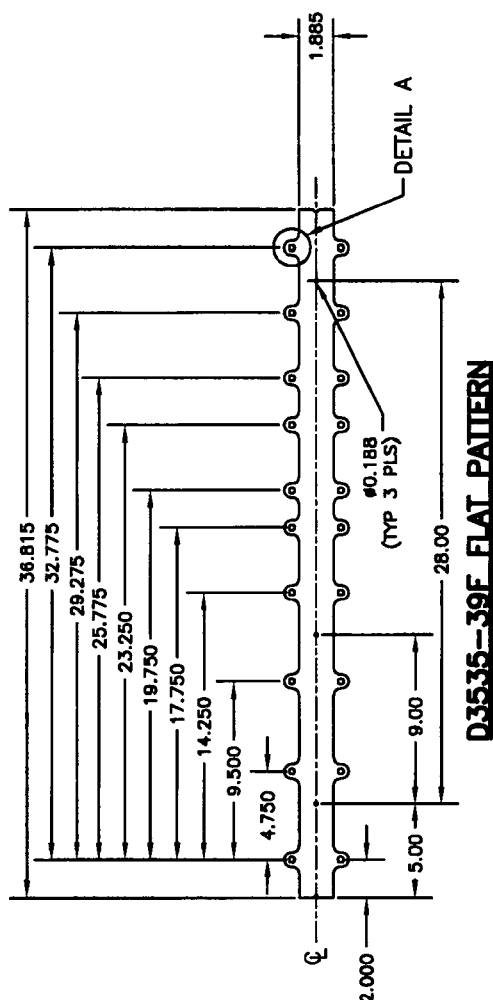
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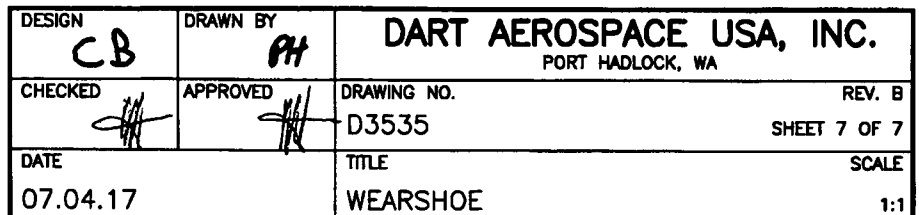


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- NOTES**
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